






Wednesday, July 13, 2011 10:22:02 AM

Page 1

Item ID:	D3457-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Washer				Stop	
Start Date:	7/14/2011	Start Qty: 60.00		Cust Item ID:		
Required Date:	7/28/2011	Req'd Qty: 60.00		Customer:		
Reference:						

Approvals: Process Plan: MF Date: 11-07-13 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3457	Rev A								

100



Doosan

Doosan Lathe

DOOSAN LATHE

Memo

Turn as per Folio FA589 Rev: AA & Dwg D3457 Rev: A

0.00

0.00

27 11. 7. 14

6

110

[illegible]

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

29 11. 7. 14

CC

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

21/7/14

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71849

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Wednesday, July 13, 2011 10:22:02 AM

Item ID: D3457-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 7/14/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *54*

0.00



Packaging

Memo

0.00

Packaging

11/7/14 *60*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/15**MF 11-07-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 10:22:00 AM

Page 1

Work Order ID: 71849

Parent Item: D3457-1

Parent Item Name: Washer





Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A 05.10.03 New issue KJ/JLM
IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.000 		Purchased		No		100	f	32.4070	0.0208	1.313684			
Delrin Round Bar 1"												11-7-14	

Location

MAT055

Loc Qty

32.407

Loc Code

117985

0.407

118257 ✓

32

21

MDELNR1.000
M118257

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

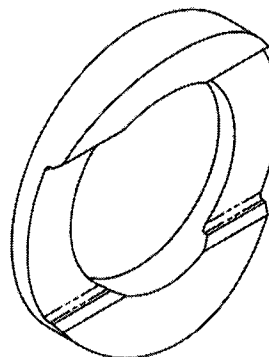
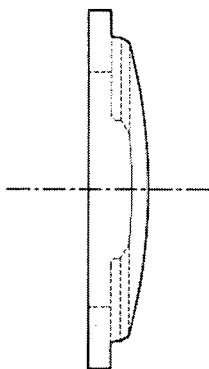
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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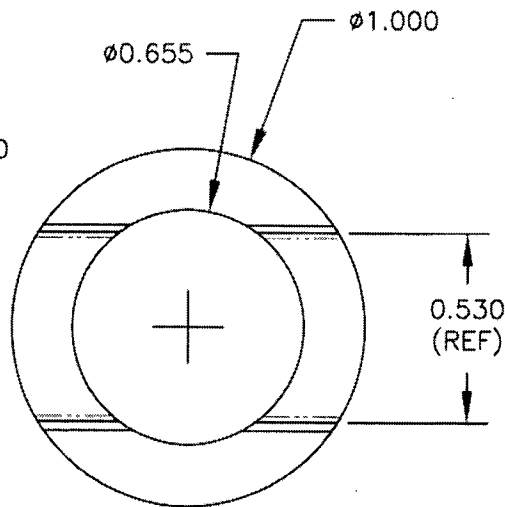
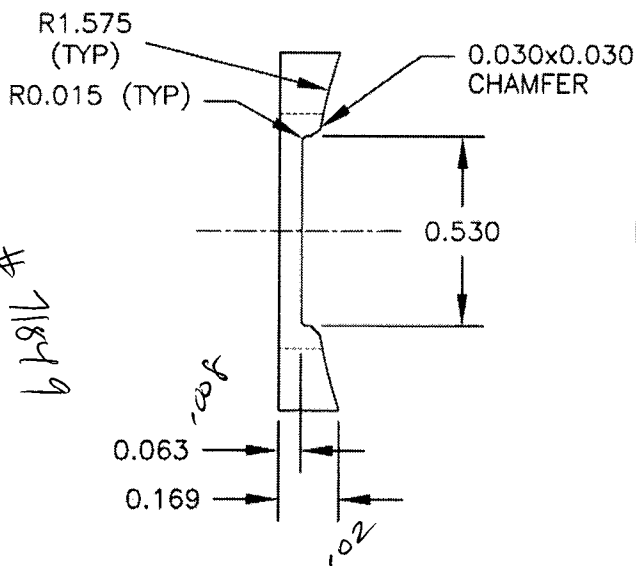


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06		TITLE WASHER	SCALE 2:1
A	05.09.06	NEW ISSUE	

RELEASED
05.09.06 #



ISOMETRIC DETAIL



D3457-1 WASHER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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